	Vork Order ID 63083 October 20, 2010 3:08:14 PM										Page 1		
Item ID: Revision ID: Item Name:	D3889-041 Panel, Floor			Accept					Setup	Start Stop			= =
Start Date: Required Date: Reference:	10/20/10 10/21/10	Start Qty: 2.00 Req'd Qty: 2.00			Cust Item I Customer:	D:							
Approvals:	Process Pla	in:	Date: <u>/0-/0-7</u>	Tooling: SPC (Y/N):		ate:			Run	Start Stop			
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	_
Draw Nbr	Rev	ision Nbr											_
D3889	A												
100		Momo		0.00				图(	0-10	26-1	>		
FLOW CNC Waterje	et	Memo 1-Cut as pe Dwg Rev:_ Prog Rev:_ 2-Deburr if	necessary								Ĝ		
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00									
QC Quality Control		Memo		0.00				IB (	<u>(0-1</u>	(O-5	۵		

W/O:			W	<b>ORK ORDER CHANG</b>	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
-								Prod Wigi	<u> </u>	
1			*16							
Part No		PAR #:	Fault Cat	egory:	_ NCR: Yes	s No <b>DQ</b>	A:	Date: _		
	R	esolution:	Dispositi	on:	QA: N/C Closed: Date:					
NCR:		1	WORK ORE	DER NON-CONFORMA	ANCE (NC	R)		79. 34.		
DATE	STEP	Description of NC	Corrective Action		on B	Verifi	cation	Approval	Approval	
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat	ı& ∣ <sub>Sec</sub>	Section C	Chief Eng	QC Inspector	
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#### Work Order ID 63083

October 20, 2010 3:08:14 PM



Page 2

Item ID:

D3889-041

Accept



Setup Start

Stop



**Revision ID:** 

**Item Name:** 

Panel, Floor

**Start Date:** 

10/20/10

Start Qty: 2.00

Req'd Qty: 2.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date: Date:

Tooling:

**SPC (Y/N):** 

Date: Date: Run

Start

Stop



Sequence ID/

Work Center ID

Required Date: 10/21/10

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject **Qty** 

Reject Insp. Number

Stamp \_

130

Small Fab

Small Fab

Memo

Deburr if necessary

0.00

0.00 =7 m/h w/w/2/

140

Packaging

Packaging

Pick Kit

Memo

0.00

0.00 Amil 10/w/21

W/O:			V	ORK ORDER CHANG	ES				
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Da	te Qty	Approval f Chief Eng / Prod Mgr	Approval QC Inspector
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		· · · · · · · · · · · · · · · · · · ·							
	:								
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Ye	es No	DQA:	_ Date: _	
	R	esolution:	Disposit	ion:	_ QA: N/C	Closed	d:	Date: _	
NCR:		W	ORK OR	DER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC			ion B		erification	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Approval Chief Eng	QC Inspector
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#### Work Order ID 63083

October 20, 2010 3:08:15 PM



Page 3

Item ID:

D3889-041

Accept



Setup Start



**Revision ID:** 

Item Name:

Panel, Floor

**Start Date:** 

Required Date: 10/21/10

10/20/10

Start Qty: 2.00 Req'd Qty: 2.00



**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Reference:

Approvals:

**Operation** 

Description

Date: Date:

Tooling:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Run

Accept

**Qty** 

Start Stop

Reject

**Qty** 

Stop



Number Stamp

Insp.

Reject

Sequence ID/ Work Center ID

150

Small Fab Small Fab

Memo

0.00

1- Bond gasket to smooth side of panel as per dwg

A/R 3M 1300 adhesive Batch:

Tool # Plan

Code

160

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

170

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

63112

63082

Capp11 0

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W/O:			WC	ORK ORDER CHANG	ES				<u> </u>
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQ</b>	A:	Date:	
	R	esolution:	Dispositio	n:	_ QA: N/C C	losed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)	-		
DATE	CTED	Description of NC		Corrective Action Section Action Description		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng		Sign & Section C		Chief Eng	QC Inspector	
	1	1	1		1	1		1	1

#### Work Order ID 63083

October 20, 2010 3:08:16 PM

Required Date: 10/21/10



Page 4

Item ID:

D3889-041

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Panel, Floor

**Start Date:** 

10/20/10

Start Qty: 2.00

Req'd Qty: 2.00

Operation

Description



**Cust Item ID: Customer:** 

Tool ID

Reference:

A	n	n	r	n	v	ล	ic	
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Process Plan:

QC:

Date:

Date: \_\_\_\_\_

**Tooling:** 

SPC (Y/N):

Set Up/

Date:

Date:

Tool # Plan

Code

Accept

Qty

Sequence ID/

**Work Center ID** 

180

Quality Control

Memo

QC21- Final Inspection - Work Order Release

**Run Hours** 

0.00

0.00

Run

Start

Reject

Qty

Stop

Reject Insp. Number

Stamp

10/10/21 des

W/O:			W	ORK ORDER CHANGI	ES			
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							:	
Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA:	Date: _	
		esolution:						
NCR:		V	WORK ORI	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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	1		\		1	1		

## **Picklist Print**

October 20, 2010 3:08:13 PM

Work Order ID: 63083

D3889-041 Parent Item:

Parent Item Name: Panel, Floor



**Start Date:** 10/20/10

Required Date: 10/21/10

Page ]

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04  GE PLASTICS LEXAN SH		Purchased	No			100	sf	1,253.803	8.1925	17.24737		-10 - >1	٥
				Location		Loc (	<u>Oty</u>	Loc Code					
				MAT	115261	1253.8 1253.8			$\overline{I}$	15 261		6	
D3889-3		Manufactured	No			140	Each :	0.0000	1   <b>               </b>	2			
Gasket					B 6	3087		S	0 10	10 2	-(	(5	

									7
W/O:			W	ORK ORDER CHANG	ES				*
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	!								
	†								
			****						
Part No		PAR #:							
	R	esolution:						Date:	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCF	<b>?</b> )			
DATE	STEP	Description of NC	124.	Corrective Action Section B Initial Action Description		Verific		Approval	Approval
	,	Section A	Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
				,					
  -  -		,							

DART AEROSPACE LTD	Work Order:	43083
Description: Panel	Part Number:	D3889-1
Inspection Dwg: D3889 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	nments
1.88	+/-0.030	1.873	\$		+ 1801		
34.0	+/-0.100	34.0	6		7		
27.35	+/-0.030	27.36	D		7		
8.37	+/-0.030	8.37	n		7		
25.35	+/-0.030	25.35	>		7		<u></u>
27.77	+/-0.030	27.75	2		7		
34.7	+/-0.100	34.658	>		7		1
14.30	+/-0.030	14,30	4		7		
20.56	+/-0.030	20.56	ب		7		
24.02	+/-0.030	24.02	<b>≫</b>		7		
23.23	+/-0.030	23.23	<b>Yes</b>		7		
0.125	+/-0.010	1131	<b>∞</b>		V BOZ	· · · · · · · · · · · · · · · · · · ·	
							·
Measured by: 🖟		Audited by:	//		Prototype Ap	proval:	N/A
		Date:	1010	2		Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	09.07.29	New Issue	P/O D3889-041	KJ 🛠	
					•

**PARTS LIST** QTY -041 ITEM DESCRIPTION D3889-041 PANEL, FLOOR D3889-1 PANEL D3889-3 GASKET D A/R 3M 1300 ADHESIVE 34.0 REF -D3889-1 PANEL D3889-3 GASKET 8 С SHOP COPY RETURN TO 34.7 REF ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 43083 **TEXTURED SIDE SHOWN-D3889-041 PANEL, FLOOR** NEW ISSUE CP 09.04.20 Α DESCRIPTION BY DATE REV. DESIGN **DART AEROSPACE LTD** 1) MATERIAL INA 2) FINISH: NONE 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED 4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3889-041" AND B/N USING FINE POINT PERMANENT INK MARKER
ON SMOOTH/UNTEXTURED SIDE OF PART D3889 MFG. APPR. SHEET 1 OF 3 TITLE APPROVED PANEL, FLOOR

7) WEIGHT: 5.13 lbs
8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

8

D

REV. A

SCALE

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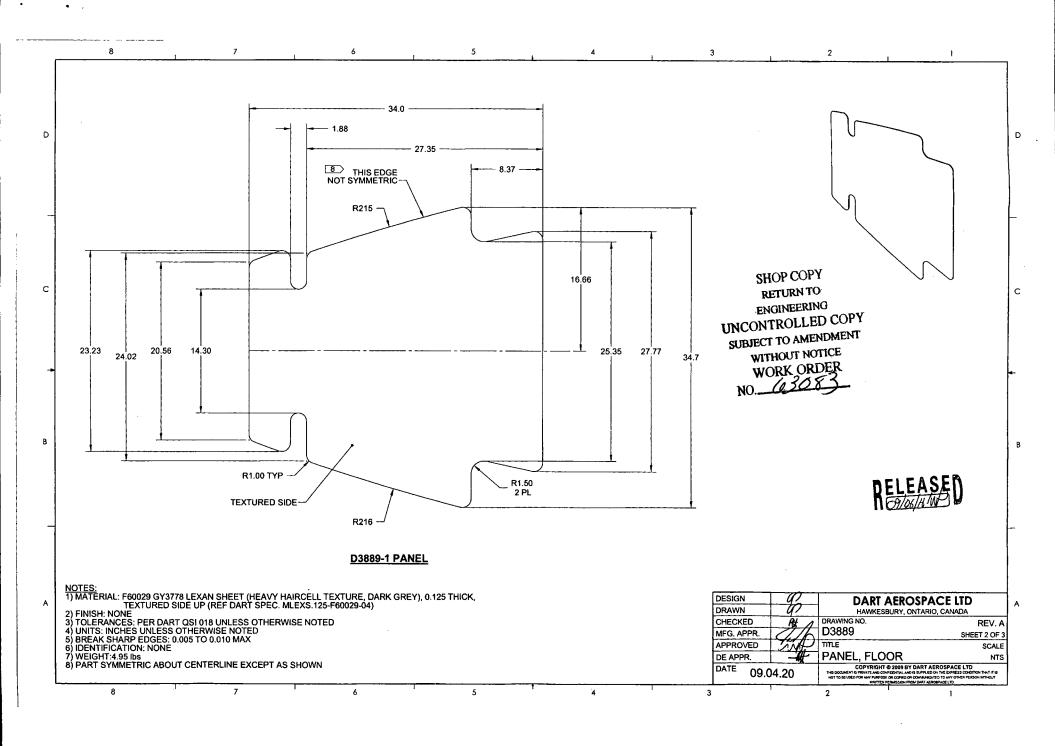
NTS

DE APPR.

09.04.20

DATE

3



D D 14.0 С **D3889-3 GASKET** NOTES:
1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK (REF DART SPEC. M4111N-S.125)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: NONE
7) WEIGHT: 0.19 lbs DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN / DRAWING NO. CHECKED REV. A D3889 MFG. APPR. SHEET 3 OF 3 APPROVED TITLE SCALE PANEL. FLOOR DE APPR. COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS COCUMENT IS PRIVATE AND CONTRIBUTING, AND IS SUPPLED ON THE EXPRESS CONDITION OF TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO MAY OTHER PERSON. DATE 09.04.20 7